

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024972**Date Inspected:** 26-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08927

**Magnetic Particle Testing (MT)**

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

**TOWER COMPONENTS**

ESD1-FGSA6-2-2

This QA Inspector observed the following work in progress

**Shielded Metal Arc Welding (SMAW):**

Weld joint #002 located on retro fit plate X3305K-037. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Weld joint #088 located on Bike path BK009A1-001. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114.

Weld joint #002 located on retro fit plate X3305K-036. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b.

Weld joint #094 located on Bike path BK009A1-001. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Weld joint #001 located on retro fit plate X3305K-038. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b.

Flux Cored Arc Welding (FCAW):

Weld joint #001 located on retro fit plate X3305K-033. Welder is identified as 054117. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #002 located on retro fit plate X3305K-033. Welder is identified as 054117. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08933

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

TOWER COMPONENTS

WSD1-TL6-4C/D-70

WSD1-FGSA6-1-20

ESD1-FESA6-2-16

ESD1-FGSA6-2-2

WSD1-FGSA6-1-2

ESD1-FFSA6-2-29

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08940

Magnetic Particle Testing (MT)

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

### TOWER COMPONENTS

ED1-SA6-4-4

WD1-SA6-4-4

SD1-SA6-4-4

ED1-SA6-6-1

ESD1-CSA6-35-2

ESD1-CSA6-37-5

ESD1-CSA6-39-2

ESD1-CSA6-41-2

ESD1-CSA6-43-2

ESD1-TL6-2B/D-68

ESD1-TL6-2C/D-1; 4

ESD1-ASA6-56-9

ESD1-FASA6-2-24

ESD1-FESA6-2-40

ESD1-TPSA6-2-9; 12

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---